

Rush

Work Order ID 144420

Monday, April 18, 2016 8:49:35 AM

647.7703
B144420
REV-A1

144420

Page 1

Item ID: 647.7703

Revision ID:

Item Name: Strut Assembly

Start Date: 4/18/2016 Start Qty: 12.00

Required Date: 5/6/2016 Req'd Qty: 12.00

Reference: REWORK AS PER ^{NCR} ~~ECN~~ 16-5719

Accept

N900040100

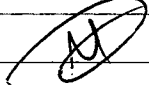
Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: 

Date: 16-4-18

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.7700

A1

105

0.00

105

HandFinish

Hand Finishing

Memo

PULL FROM STOCK
647.7703 X12
B: 140786

0.00

STRIP PARTS TO BE RECAD PLATED

^{NCR}
AS PER ~~ECN~~ 16-5719

DAS

41

9-89

16-4-19

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

150

Outsource3

Outsource process - Cad plate

Memo

Issue P/O: 32083
C of C is required

1,440.00

DAS

13

9-89

APR 19 2016

Receiving

12x Sp 16-04-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Work Order ID 144420

Monday, April 18, 2016 8:49:35 AM

144420

Page 3

Item ID: 647.7703 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly
 Start Date: 4/18/2016 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 12.00 *12* Customer:
 Reference: REWORK AS PER ECN16-5719

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>CCF114</u>	0.00							
200									
Packaging	Memo	0.12				12	MLJ	16-05-03	
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	1.20				MLJ		MAY 04 2016	
Quality Control									

MLJ MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

Picklist Print

Monday, April 18, 2016 8:49:41 AM

Page 1

Work Order ID: 144420

144420

Parent Item: 647.7703

647 7703

Parent Item Name: Strut Assembly

Start Date: 4/18/2016

Required Date: 5/6/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7703		Manufactured	No				Each	0.0000		12			

647 7703

Strut Assembly

**

B140786

16-4-12

~~12x 8p/60/28~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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OTHER : ☐					



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

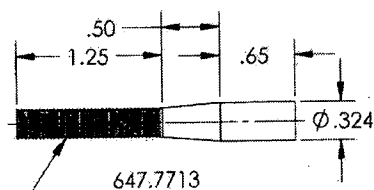
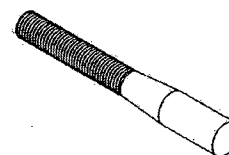
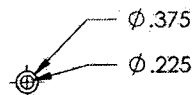
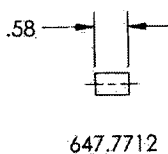
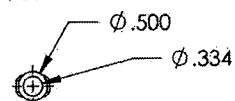
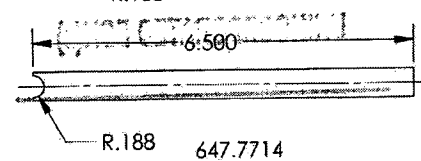
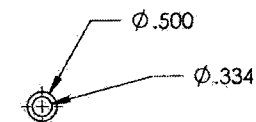
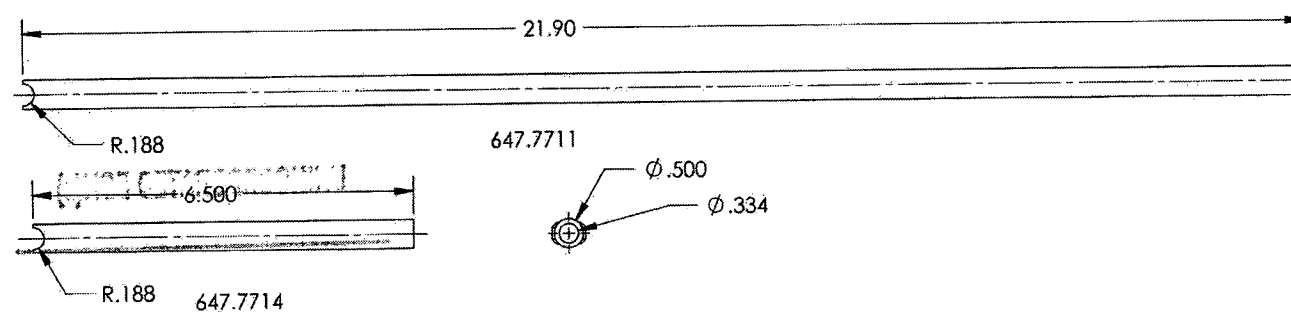
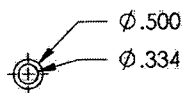
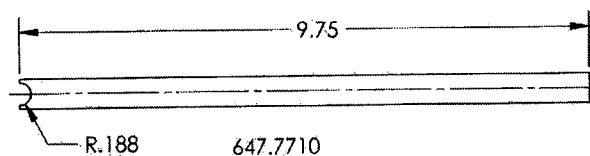
NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX.
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

16-4-18
144420

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY ☐ MAJOR ☐ MINOR					
DER REVIEW REQUIRED ☐ YES ☐ NO					

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



1/4 - 28 THREAD

ORIGINAL DATE 11/03/09		APICAL INDUSTRIES	
DRAWN BY J. JACKSON	CHECKED J. JACKSON	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		STRUT ASSY	
CONTRACT NO.		REV.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	REV. B	DWG. NO. 647.7700	REV. A
SCALE: NONE		SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32083

Purchase Order Date 4/19/2016

PO Print Date 4/19/2016

Page Number 1 of 2

Order From :

VC-ALT01

Ship To : DART AEROSPACE LTD

GROUP ALTECH
2455 HALPERN

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

ST LAURENT, MONTREAL H4S 1N9

Contact Name

Vendor Phone 514-335-3666

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

APR 19 2016

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	144420	647.7703 STRUT ASSEMBLY	4/27/2016	Yes	12.00	\$24.58	\$295.00
			4/27/2016				

Cad Plating is to be done per QQ-P-416F Class I Type II.
PLEASE NOTE: HYDROGEN ENDBRITALEMENT IS INCLUDED IN PRICING PER UNIT

Sp/16-04-28

Line Total: \$295.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	4/27/2016	No	1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Note:

4/19/2016



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.: (514) 335-3666 Fax.: (514) 335-3868
Internet : www.groupaltech.com

Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance

Bon-Livraison / Pk.Slip # : 117583-1 26/04/2016
Bon-Commande. / W.Order # : 117583
Client P.O. # : 32083
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	647.7703 Rev.	✓ CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITAMENT RELIEF (BAKE)	0.00	12	12	0

Sdber-28

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.